

Work Order ID 164243 -1

Monday, July 17, 2017 1:58:42 PM

164243

Page 1

Item ID: D2680-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Nut Plate

Stop *NS2*

Start Date: 8/4/2017 Start Qty: 40.00

40

Cust Item ID:

Required Date: 9/25/2017 Req'd Qty: 40.00

40

Customer:

Reference:

DAS

21

9-89

Approvals: Process Plan: Date: JUL 17 2017

Tooling:

Date:

Run Start *NR1*

QC: Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2680	Rev B1

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.69

FLOW CNC Waterjet

1-Cut as per Dwg D2680 Dwg Rev: B1 Prog Rev: B1 2-
Deburr if necessary

(40)

07/17/21

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.40

Quality Control

(40)

07/17/21

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.80

Quality Control

40

DAS
38
9-89

JUL 24 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐			
Design ☐	☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐			
Doc/Data ☐	☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐			
Equip/Tooling ☐	☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐			
Handling/Pre ☐	☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐			
Material ☐	☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐			
Internal Transport ☐	☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐			
Tribal Knowledge ☐	☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐			
LOA ☐	☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐			
Substation ☐	☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐			
Past Expiry Date ☐	☐	Manufacturing Process ☐	OTHER :						
Misidentified ☐	☐	Past Due ☐							

Work Order ID 164243

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab					40x			17/07/25 DAS 36 9-89
Small Fab	Memo	1.06							
Small Fab	1- Debur 2-C'sink as per Dwg D2680								
140		0.00							
140	QC5- Inspect part completeness to step on W/O					40			DAS 38 9-89
QC	Memo	0.80							
Quality Control									JUL 25 2017
145		0.00							
145						W 40			JLB 2017/07/31
SprayPaint	Memo	0.00							
Spray Painting	PRIME B 37273								
	DEFLEET BLUE B								
	DEFLEET CLEAR B								

147 -

Receive

20x SPT-8-1

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Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

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Page 3

Stop *NS2*

Customer:

Stop ***NR2***

NR2

Insp.
Stamp

Quality Control

Small Fab

Install Nut Plate as per Dwg D2680

Memo

Quality Control

22

DAS
22

AUG 07 2017

20x

17/08/21

DAS
36

20

DA
38

AUG 01 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

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164243

Page 4

Item ID: D2680-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Nut Plate
Start Date: 8/4/2017 Start Qty: 40.00 ***40*** Cust Item ID:
Required Date: 9/25/2017 Req'd Qty: 40.00 ***40*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00							
190									
Packaging	Memo	0.40							
Packaging	LOCATION :LG001								
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	4.00							
Quality Control									

20 B/UE DAS 6 9-89 AUG 02 2017

17/8/2017

AUG 02 2017

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WORK ORDER NON-CONFORMANCE / UPDATE



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Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

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164243

D2680-041

Required Qty: 40.00

Comments: IPP: D04.10.01Added Steps 2-4, 7-8KJ/JLM
IPP Rev:E Now on WaterJet 06-10-12 JLM
IPP rev F QC5 after c'sink 07.07.05 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21069L4		Purchased	No			110	Each	101.0000	1	40			
MS21069L4 Nut Plate													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST299				101					
				m137459				1					
				m137710				100					
M1010S16GA		Purchased	No			170	sf	75.0509	0.0131	0.551579			
M1010S16GA 1010/1025 sheet 16GA													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				MAT019				75.050947					
				124428				75.050947					
MS20426AD3-3		Purchased	No			170	Each	2,047.000	2	80			
MS20426AD3-3 RIVET													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				FG107/108				80					
				M137350				80					
				fg108				200					
				M134946				200					
				ST312				1767					
				M135274				1767					

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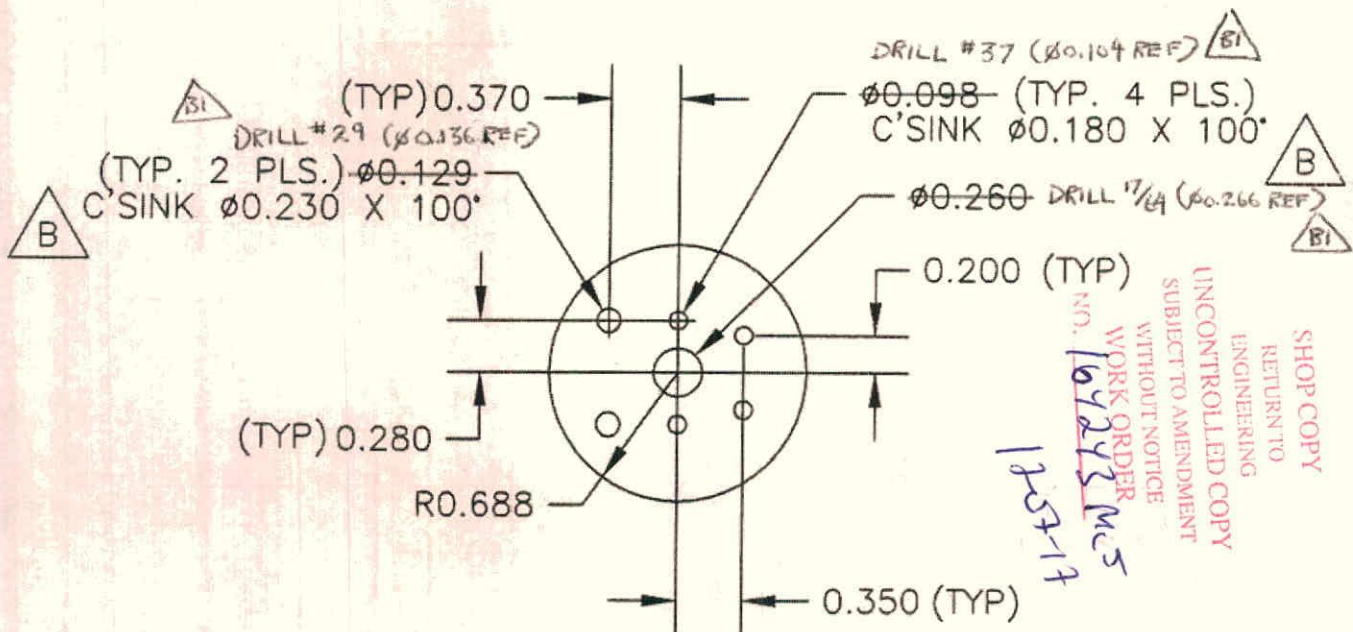
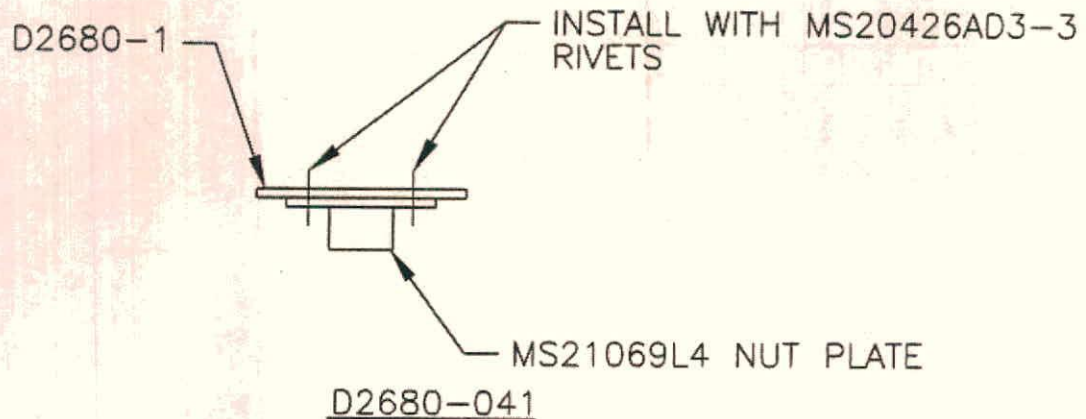
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		OTHER : ☐																							

DART

COPY ISSUED

DESIGN #	DRAWN BY #	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED P	APPROVED KE	DRAWING NO. D2680	REV. B SHEET 1 OF 1
DATE 98.12.14	TITLE NUT PLATE		SCALE 1:1
A	97.09.15	NEW ISSUE	
B	98.12.14	CHANGE C'SINKS (PER TSR A1041)	
B1	CP-# 04.11.04	CHANGE HOLES & FINISH	

RELEASED
98.12.14 DS



MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.063 THICK (16 GAUGE)

CAD PLATE PRIOR TO INSTALLATION OF MS21069L4

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

B1 POWDER COAT WHITE (4.3 S. 2) PER DART QSI QWS 4.3
D2680-1

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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO37273

Purchase Order Date 7/31/2017

PO Print Date 7/31/2017

Page Number 2 of 2

Order From :

VC-ATE001

Ship To : DART AEROSPACE LTD

ATELIER DEBOSELAGE
358 PRINCIPALE
CALUMET, QC J0V 1B0
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 819 242 5633

Buyer

Diane Baker

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Line Total: \$192.00

4 164243

D2680-041 Nut Plate

7/31/2017

40.00

\$4.00

\$160.00

Yes

7/31/2017

Prime and Paint Deflect Blue
As per Dwg D2680 Rev. B1

Line Total: \$160.00

PO Total:

DAS
38
9-89

\$736.00

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr:

2

Change Date:

7/31/2017

